







Date: Tuesday, 23/09/2008 10:22:48 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FRONT OUTBOARD LEG (LH)
Job Number : 42239	
Estimate Number : 13376	
P.O. Number :	Part Number : D37683
This Issue : 23/09/2008 S.O. No. :	Drawing Number : D3768 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 40973	Material :
Written By :	Due Date : 05/10/2008 Qty: 8 Um: Each
Checked & Approved By : <u>JUL 28.9.23</u>	
Comment : Est Rev:A 08-06-18 rev.A as per dwg DD verified by:EC Est Rev:B 08-08-25 Rev B Added Drilling tooling JLM Verified By:EC	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation:
Description :	
1.0	M6061T6T1000W065
	6061T6 RD TUBE 1.00 x .065w
	
Comment: Qty.: 1 f(s)/Unit Total : 7 f(s) 6061T6 TUBE (1.00" x 0.65" wall) batch: <u>M109760</u> (6x) <u>M109116</u> (2x) <u>M-1</u> 09/01/05	
2.0	SMALL FAB 1
	SMALL & MEDIUM FAB RESOURCE 1
	
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-CUT TUBE TO LENGH AS PER DWG D3768 2-DRILL TUBE USING DT9044 AND AS PER DWG D3768 3-DEBURR <u>M-1</u> 09/01/13 <u>FF</u> 09/01/13 <u>M-1</u> 09/01/05	
3.0	QC5
	INSPECT WORK TO CURRENT STEP
	
Comment: INSPECT WORK TO CURRENT STEP <u>S</u> 09/01/14 (48)	
4.0	HAND FINISHING1
	HAND FINISHING RESOURCE #1
	
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <u>YJ</u> 09-01-20 (48)	
5.0	POWDER COATING
	POWDER COATING
	
Comment: POWDER COATING Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 <u>YJ</u> 09-01-22 (48)	

W/O: 42239		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3768-3 PAR #: N/A Fault Category: Sm/Prod Part NCR: Yes No DQA: JA Date: 09.01.26
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: JA Date: 09.01.27

NCR: 42239		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/1/8	# 2.0	During inspection it was found that Qty (X5) of parts have one hole ovalized to 0.340" (dim should be 0.323" +.006" - .01")	09.01.08 QSF 042	Scrap and Destroy and Replace Qty (X5) M# 108961	M-L 09/01/13	S 09/01/14	PT 09.01.08 PDR QSF 042	S 09/01/08
		R.C. empops drilling the holes and new employee technique		- ensure employee is shown proper drilling techniques.	FF 09/01/13	S 09/01/14		S 09/01/08
		- TRAINING						

NOTE: Date & initial all entries

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User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRONT OUTBOARD LEG (LH)

Job Number: 42239

Part Number: D37683

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

11:14 AM

OVEN TEMPERATURE:

320°F

FINISH TIME:

12:15 PM

HL

09-01-22

(S)

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(S)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL

09/01/22

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

STV93

AS

09/01/22

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/23

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



HL 09-01-23

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

D

C

C

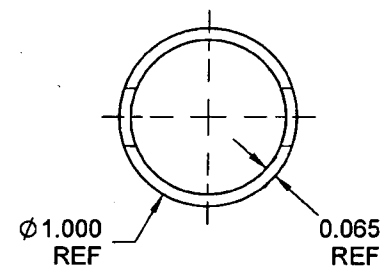
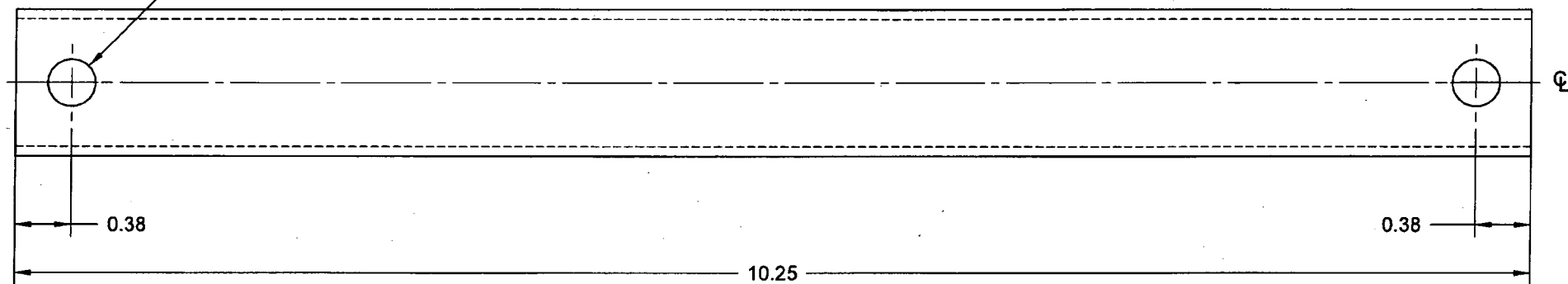
B

B

D3768-1 FRONT INBOARD LEG**D3768-3 FRONT OUTBOARD LEG, LH****D3768-4 FRONT OUTBOARD LEG, RH****RELEASED**
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NO. 45231**NOTES:**





- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" OD X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.00W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "FIRE RED" (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

A	NEW ISSUE	HS	08.06.04
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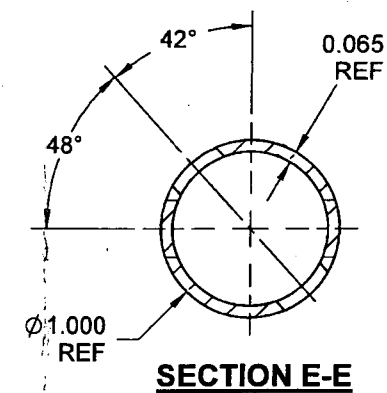
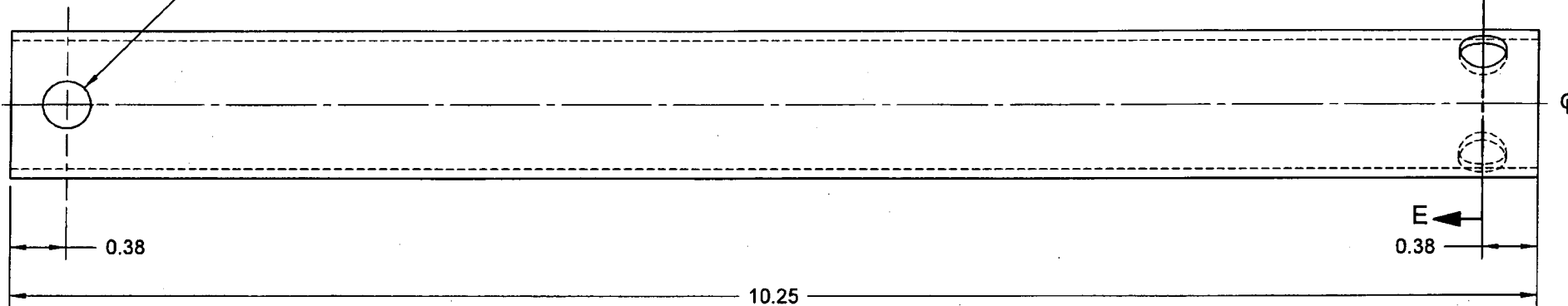


D3768-1 FRONT INBOARD LEG

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(2PL)



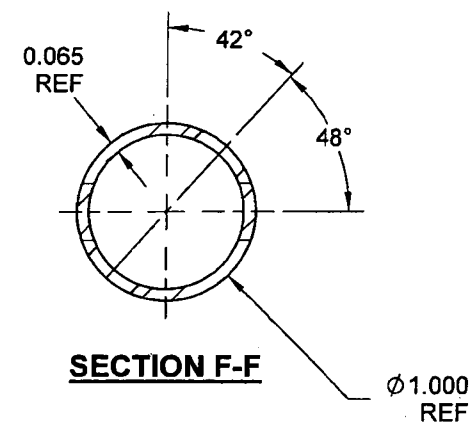
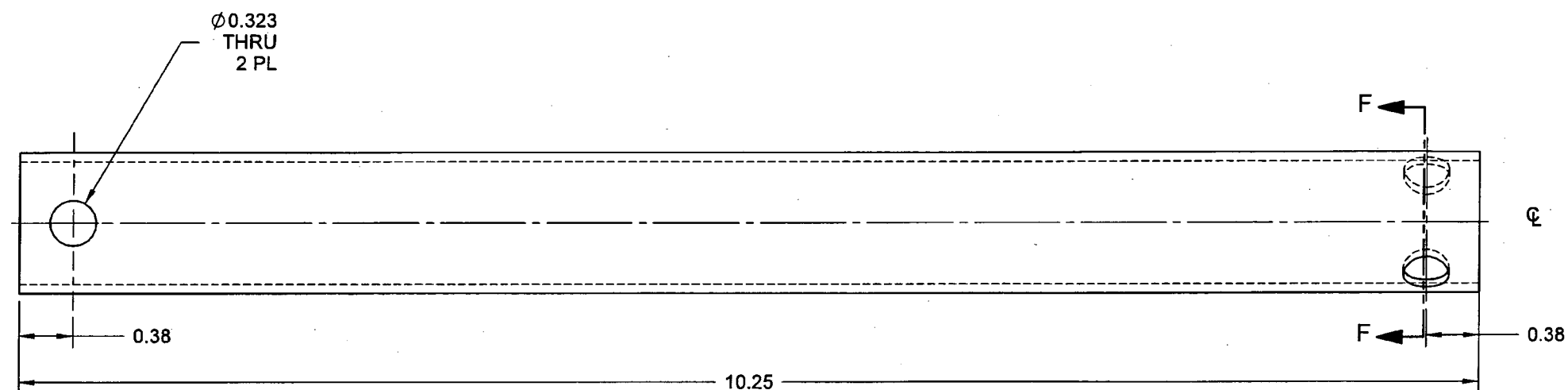
218

D3768-3 FRONT OUTBOARD LEG, LH

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D3768-4 FRONT OUTBOARD LEG, RH

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